

Work Order ID 129412

Friday, February 06, 2015 11:19:26 AM

129412

Page 1

Item ID: D3757-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Blanking Plate

Start Date: 2/6/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/6/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 15-02-06 Tooling:

Date:

Run Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3757

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3757 Dwg Rev: A Prog Rev: A

304.063"

17 Ø Jm15-2-10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

17 Ø Jm15-2-10

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

17

DAS
38
9-89

FEB 11 2015

Work Order ID 129412

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*Rush!****129412***

Page 2

Item ID: D3757-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blanking Plate

Start Date: 2/6/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/6/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

Small Fab

Memo

1-Deburr if necessary

0.00

DAS 38 9-88 0.00

N/A

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

DAS 38 9-88 0.00

N/A

150

150

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

0.00

0.00

START TIME:

9:00 FINISH TIME:

OVEN TEMPERATURE:

9:30

*M 129808**17.0 15.2-12. DAS 34 9-88*

Work Order ID 129412

129412

Page 3

Item ID: D3757-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Blanking Plate

Start Date: 2/6/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 2/6/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>st 059</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
FEB 12 2015

DAS
27
9-89
FEB 13 2015

15/2/17 AJ

152-13

Picklist Print

Friday, February 06, 2015 11:19:31 AM

Page 1

Work Order ID: 129412

129412

Parent Item: D3757-1

D3757-1

Parent Item Name: Blanking Plate

Start Date: 2/6/2015

Required Date: 2/6/2015

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-01-30 new issue DD verified by:EC
IPP Rev:B 08-02-27 rev.A as per ecn 1139 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

251.8992

0.0622

1

M304S16GA

**

304/316 Sheet .063

Jm 15-2-14

Location

Loc Qty

Loc Code

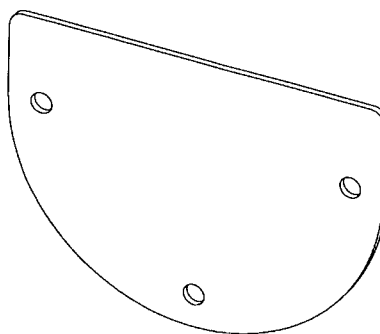
MAT019

251.8992

m131384

251.8992

131384



D3757-1 BLANKING PLATE

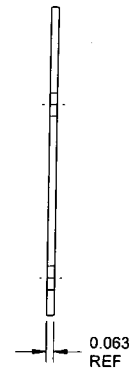
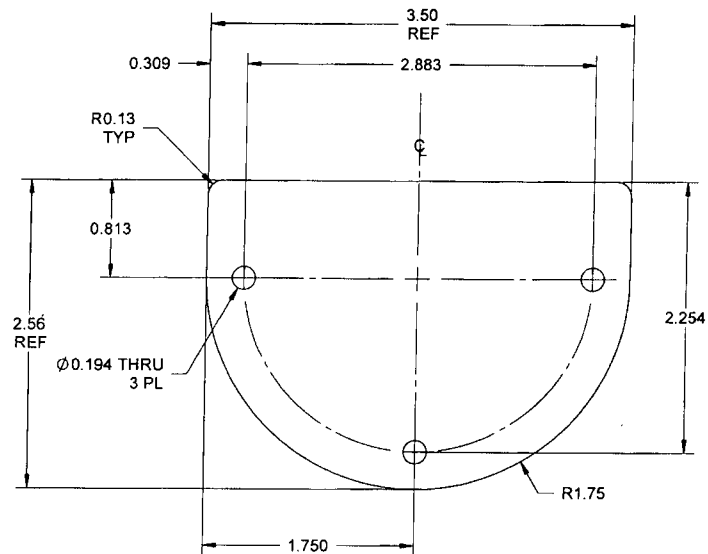
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET
PER MIL-S-5059 (ANNEALED)
(REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3757-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.14 lbs

NO. 129412 MLC
1502-D6

08.02.25

A	NEW ISSUE	MB	08.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3757	SHEET 1 OF 2
APPROVED		TITLE	SCALE
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D3757-1 BLANKING PLATE

11.2.2010
16.08.2013

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CHECKED	MB	DRAWING NO. D3757	REV. A
MFG. APPR.	MB	SHEET 2 OF 2	
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